

5/43

DART AEROSPACE LTD		Work Order:	24586
Description: Stem		Part Number:	D3407-1*
Dwg: D3407 Rev. C		Qty:	6
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HJ	05.10.18	6
2	MC	Turn as per Folio FA596 Rev: <u>A</u> & Dwg D3407 Rev: <u>MC</u> Material: 17-4ph SS Round Bar Ø0.750 (M17-4-R0.750) Identify for D3407-1 Batch: <u>M18742</u>	FM	05/10/21	6
3	QC2	Inspect parts as they come off the machine	FM	05/10/21	6
4	QC8	Second check	SD	05.10.23	6
5	MC	Deburr, no sharp edges	FM	05/10/21	6
6	MV	Machine as per Folio FA596 and Dwg D3407	SD	05.10.23	6
7	QC2	Inspect parts as they come off the machine Identify as D3407-1	SD	05.10.23	6
8	QC8	Second check	BL	05.10.24	6
9	MV	Deburr	SD	05.10.23	6
10	ST	Identify and Stock	PL	05.10.24	6
11	AC	Cost / part: <u>29,50</u>	JUC	05-10-25	6
12	DC	Close W/O <u>29,50</u> Inspect Level 21	LD	05/10/25	6

Rev	Date	Change	Revised By	Approved
A	05.10.18	New issue	KJ/EC	EC

RELEASED
05.10.18

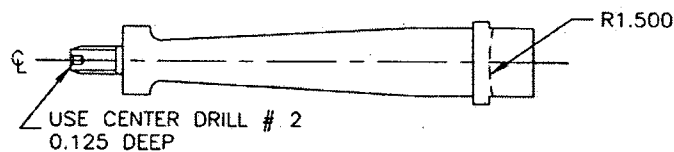
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 05/10/25

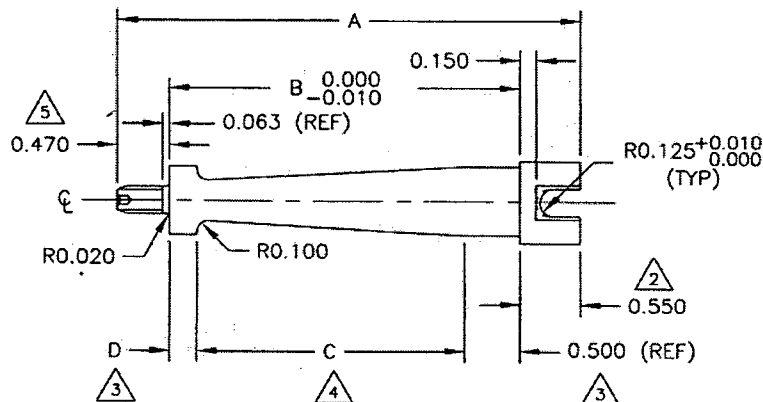
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



RELEASED

05.09.12



PART NUMBER	A	B	C	D
D3407-1	5.270	4.250	3.250	0.500
D3407-3	4.325	3.305	2.555	0.250

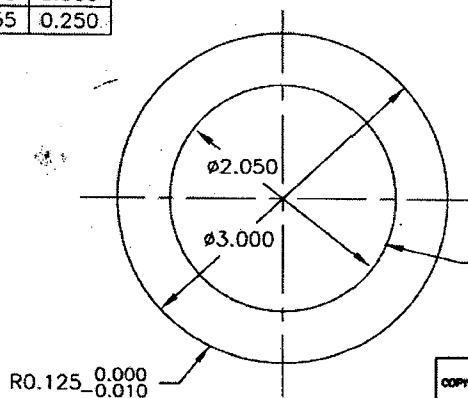
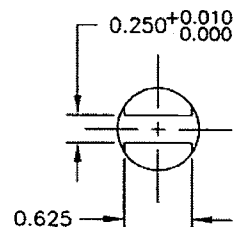
D3407-1/-3 STEM

D3407-1 AND D3407-3 STEM:

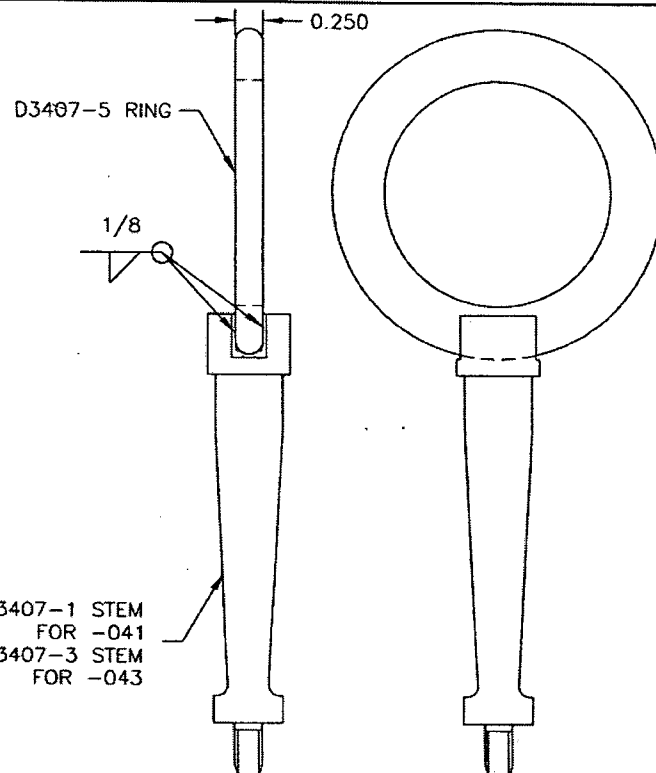
- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2) $\phi 0.750$ O.D.
- 3) $\phi 0.625$ O.D.
- 4) MACHINE UNIFORM TAPER FROM $\phi 0.363$ O.D. TO $\phi 0.625$ O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3407-5 RING:

- 9) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3407-5 RING



USE D3407-1 STEM FOR -041
USE D3407-3 STEM FOR -043

D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEBURR 0.010 TO 0.020

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C	05.09.09	-1/-3 LONGER FOR FIT W/ WASHER
B	05.06.17	UPDATE DIAMETER, THREAD CLASS ADDED
A	05.03.16	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	CP	APPROVED
DATE	05.09.09	TOW RING
DRAWING NO.	D3407	REV. 2
DART AEROSPACE USA, INC.		SHEET 1 OF 1
PORT HAVEN, MA		SCALE 1:1

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NOT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 24586

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 18, 2005
09:31 am

Work Order No : 0024586
Project Name : D3407-1
Project For : WK543
Work Order Type : Main
Main WO Number :
House Part Number : D3407-1

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Description : Stem
Manufactured : No
Amount Req'd : *86*
Amount Done : 0
Start Date : 10-18-05
Est Finish Date : 10-21-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 24586
Description: STEM	Part Number: D3407-1	
Inspection Dwg: D3407 Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.270	$\pm .010$	5.271	✓			
4.250	$\pm .000$ $\pm .010$	4.244	✓			
3.250	$\pm .010$	3.257	✓			
0.500	$\pm .010$	0.499	✓			
0.063	$\pm .010$	0.070	✓			
0.470	$\pm .010$	0.466	✓			
R0.020	$\pm .010$	R 0.020	✓			
0.500	$\pm .010$	0.492	✓			
0.550	$\pm .010$	0.550	✓			
0.625	$\pm .010$					
0.250	$\pm .010$ $\pm .000$					
1/4 28 UNE	N/A	✓	✓			
Ø 0.750	$\pm .010$	0.750	✓			
Ø 0.625	$\pm .010$	0.626	✓			

Measured by: Jml	Audited by: En	Prototype Approval: D PH
Date: 05/10/21	Date: 05/10/21	Date: 05.10.24

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

